

Work Order ID 63640

Monday, November 08, 2010 8:32:00 AM



SHIP TODAY

Page 1

Item ID: D4122-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd

Start Date: 11/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 10-11-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4122

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B10-11-8

(1)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-11-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/10/08

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63640

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Start Date: 11/8/2010 Start Qty: 1.00

Required Date: 11/8/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

10/11/08 sf

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Monday, November 08, 2010 8:32:00 AM

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Item ID: D4122-1

Accept

Revision ID:

Item Name: Floor Protector, Fwd

Start Date: 11/8/2010 Start Qty: 1.00

Required Date: 11/8/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/08
MF
10-11-8

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Picklist Print

Monday, November 08, 2010 8:31:59 AM

Page 1

Work Order ID: 63640



Parent Item: D4122-1



Parent Item Name: Floor Protector, Fwd

Start Date: 11/8/2010

Required Date: 11/8/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.04 new issue DD verf:JLM
10.10.14 AS PER REV.B DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	944.8038	27.143	28.57158			



GE PLASTICS LEXAN SHEET



B10-11-8

Location

Loc Qty

Loc Code

MAT

944.8038

115261

944.8038

115261

①

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DART AEROSPACE LTD		Work Order: 63040
Description: Floor Protector, Fwd		Part Number: D4122-1
Inspection Dwg: D4122	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.012/-0.001	3.005	✓		UB 02	
1.50	+/-0.030	1.498	✓		✓	
2.76	+/-0.030	2.755	✓		✓	
3.70	+/-0.030	3.700	✓		✓	
9.63	+/-0.030	9.63	✓		T B 01	
16.00	+/-0.030	16.00	✓		T	
27.26	+/-0.030	26.26	✓		T	
27.76	+/-0.030	27.76	✓		T	
31.00	+/-0.030	31.00	✓		T	
34.51	+/-0.030	34.51	✓		T	
41.88	+/-0.030	41.88	✓		T	
73.00	+/-0.030	73.00	✓		T	
78.75	+/-0.030	78.75	✓		T	
83.66	+/-0.030	83.66	✓		T	
6.65	+/-0.030	6.65	✓		T	
11.52	+/-0.030	11.52	✓		T	
15.92	+/-0.030	15.92	✓		T	
35.15	+/-0.030	35.15	✓		T	
35.65	+/-0.030	35.65	✓		T	
57.65	+/-0.030	57.65	✓		T	
58.15	+/-0.030	58.15	✓		T	
77.40	+/-0.030	77.40	✓		T	
81.77	+/-0.030	81.77	✓		T	
86.65	+/-0.030	86.65	✓		T	
93.29	+/-0.030	93.29	✓		T	
0.125	+/-0.010	.127	✓		✓	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 10-14-8	Date: 10/11/05	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.25	Dimensions updated per Dwg Rev B	KJ	MA

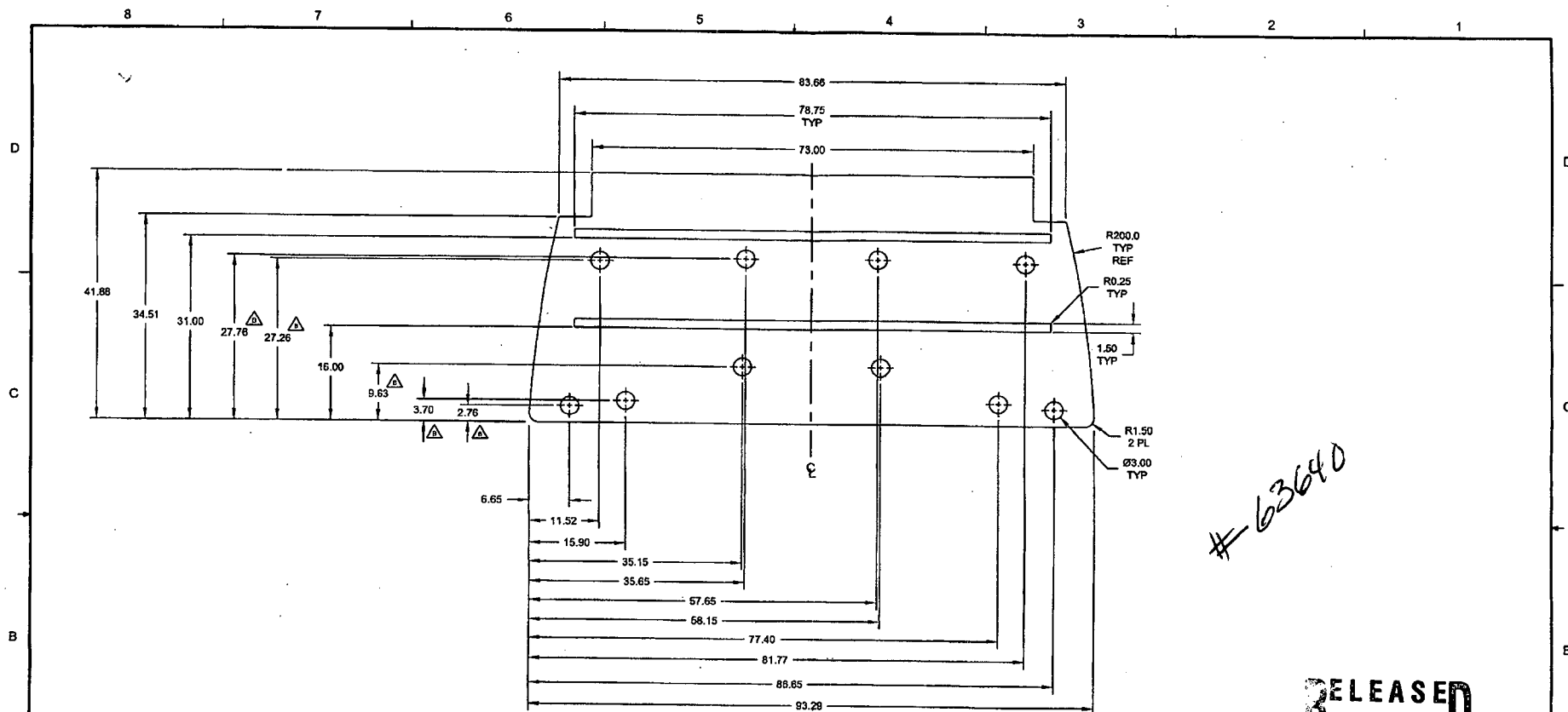
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D4122-1 FLOOR PROTECTOR, FORWARD

RELEASED
2010-10-24

PER ECN 10-633

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D4122-1" PER DART QSI 044 6.1
- 7) WEIGHT: 18.18 lbs

B	EDGE CUT OUTS REMOVED, ALL HOLES ARE MOVED. 5/8" FWD	SC	10.10.13
A	NEW ISSUE	SC	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	PP	D4122	SHEET 1 OF 2
MFG. APPR.	W	TITLE	SCALE
APPROVED	W	CABIN FLOOR PROTECTOR	NTS
DE APPR.	W	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.10.13		

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